

Date: Monday, 03/11/2008 1:30:29 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : STRUT
<b>Job Number</b> : 43164	
<b>Estimate Number</b> : 11557	
<b>P.O. Number</b> :	<b>Part Number</b> : D30841
<b>This Issue</b> : 03/11/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3084 REV A
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : LARGE FAB ASSY	<b>Drawing Revision</b> : A
<b>Previous Run</b> : 26792	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 15/11/2008 <b>Qty:</b> 6 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JUD 08.11.03</u>	
<b>Comment</b> : Est. C 02.05.11 Added welding rod batch number NG	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M6061T6T0750W058	6061-T6 RD Tube .750 x.058W
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**Comment:** Qty.: 3.3249 f(s)/Unit Total: 19.9496 f(s)

6061-T6 Tube .750 x.058W

Material: .750 Dia X .058 wall 6061-T6(ww-t-700/6)Seamless Aluminum tubing

Batch

No: 110099

SB 08/01/08

(7)

2.0	BAND SAW	BAND SAW
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**Comment:** BAND SAW

Punch per Dwg. D3084 and spec control dwg D2638

Open hole to .3230 as per dwg, one side only

Deburr

SB 08/01/08

M-H 09/01/12

(7)

(7)

3.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP

S 09/01/13

(7)

4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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**Comment:** LARGE FABRICATION RESOURCE 1

Weld ends per QSI 004. Use aluminum rod

Grind flush.

Batch: 1104855

M-H 09/01/14

FF 09/01/14

SP 09.01.13

(7x)

(7)

5.0	QC9	VISUAL WELDING INSPECTION
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**Comment:** VISUAL WELDING INSPECTION

BE 09-01-14

(7x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 03/11/2008 1:30:30 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 43164

Part Number: D30841

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

508/01/14 (7P)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

11:15am

OVEN TEMPERATURE:

320°F

FINISH TIME:

1:45am

9/1

09-01-15

✓7

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FZ 09/01/15

(7)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

hac 271

9/1/15

(17X) 30

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/16

Job Completion



MF 09-01-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

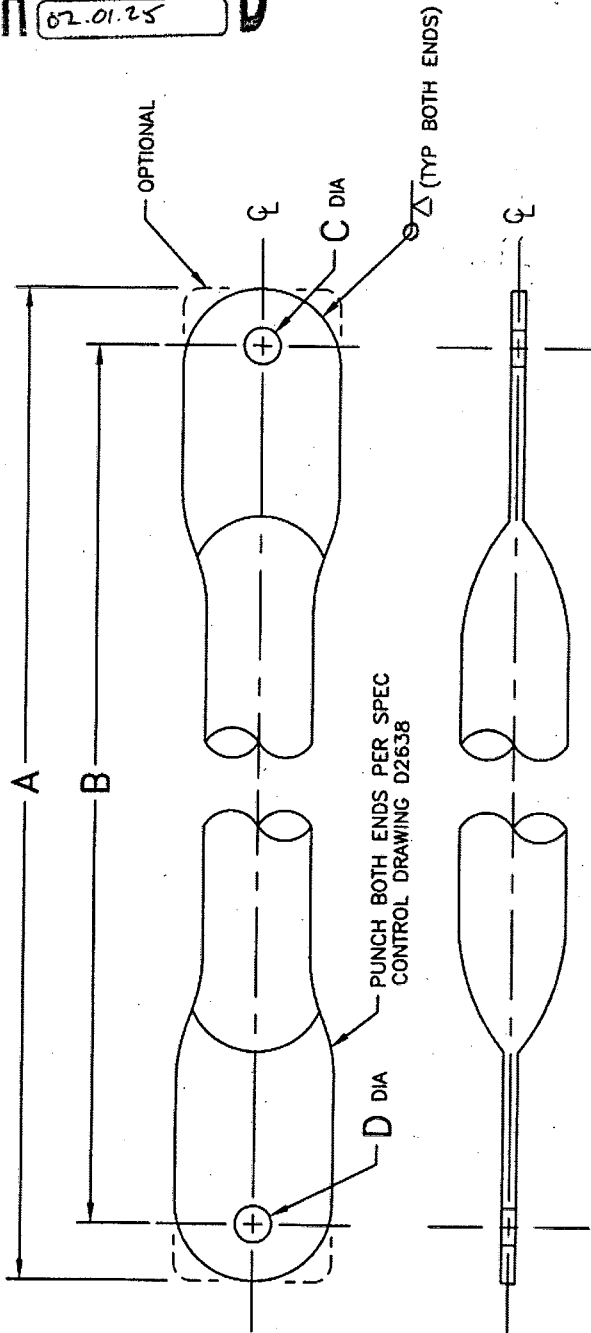
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3084	REV. A SHEET 1 OF 1
DATE 02.01.21		TITLE STRUT	SCALE NTS
A	02.01.21	NEW ISSUE	

**RELEASED**  
02.01.25

	A	B	C	D
D3084-1	37.18	36.38	0.257	0.323

NOTES:  
1. MAKE PER TEMPLATE DT3084-XX WHERE XX IS THE RESPECTIVE DASH NUMBER  
2. MATERIAL: 6061-T6 (WV-T-700/6) SEAMLESS TUBE Ø0.750 x 0.058 WALL  
3. WELD ENDS PER DART QSI 004 AND GRIND FLUSH  
4. FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
5. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
6. ALL DIMENSIONS ARE IN INCHES

SHOP COPY  
RETURN TO  
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 4364

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

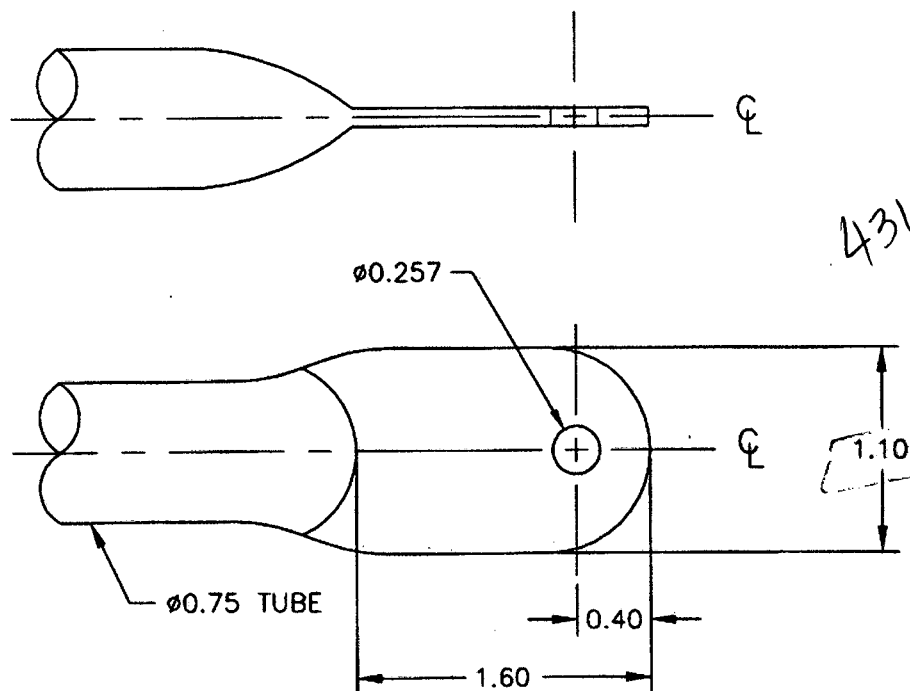
NOTE: Date & initial all entries



DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED ME	APPROVED KE	DRAWING NO. D2638	REV. A SHEET 1 OF 1
DATE 98.04.28		TITLE PUNCH DT8117 SPEC CONTROL	SCALE 1:1
A	98.04.28	NEW ISSUE	

RELEASED  
98/05/05 KE

## SPECIFICATION CONTROL DRAWING FOR PUNCH DT8117



REFERENCE ONLY

